

Date: Friday, 11/18/2005 6:54:49 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X48")
Job Number	: 24834		
Estimate Number	: 10768		
P.O. Number	: N/A	Part Number	: K10015
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Number	: D2521 REV I
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: N/A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment below</u>	Due Date	: 11/30/2005
Checked & Approved By	: <u>See Comment below</u>	Qty:	10 Um: Each
Comment	: Est Rev:D 05.06.20 Forming removed KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10015

D205-564-011

D430-688-011

and create labels per PPP K10015 CHG002

(Bag Bluefiles separately)

DH 05/11/28 (10)

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8242 sf(s)/Unit Total: 34.1208 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: 718612 / M19055 ED 05/11/28 10

3.0	HAAS1 (8) (12)	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

Per 05/11/28 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X48")

Job Number: 24834

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 05/11/26 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 05/11/26 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B055

Clamp Cushion, Black



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055

Rubber Cushion

B23172

D2274

Radius Block



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2274

Radius Block

B24066

2 D2521(ref only)

Bearpaw

B24834

8 D2947

Clamp

B23188

9.0

D2529

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2529

Washer

B23177

10.0

AN415A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 6:54:49 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X48")

Job Number: 24834

Part Number: K10015

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 AN4-15A

Bolt

M17566

11.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M18136

12.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 MS21042L4 Nut (or -4) M17987

05/11/28 10 Day 189

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

05/11/28 10

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10015

Location: _____

REV D

05/11/28 10

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

05/11/30 (10)

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024834	Department Code:	
Project Name	: K10015	Burden Flags	: NNNNNNNN
Project For	: WK548	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10015	Invoice Number	:
Description	: Bearpaw Kit	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 5	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 11-30-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order:	24834
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521	Rev: I	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	+/-0.030	1.002	—			
B	5.60	+/-0.030	5.594	—			
C	11.50	+/-0.030	11.50	—			
D	10.250	+/-0.010	10.259	—			
E	13.250	+/-0.010	13.250	—			
F	8.500	+/-0.010	8.510	✓			
G	22.13	+/-0.030	22.125	—			
H	8.75	+/-0.030	8.754	✓			
I	44.50	+/-0.030	44.56	—			
J	6.69	+/-0.030	6.697	—			
K	5.63	+/-0.030	5.619	—			
L	7.000	+/-0.030	7.002	✓			
M	5.000	+/-0.010	5.005	—			
N	4.00	+/-0.030	4.001	—			
O	6.63	+/-0.030	6.637	—			
P	19.00	+/-0.030	19.00	✓			
Q	0.31 x 45°	+/-0.030	0.31 x 45°	✓			
R	0.19 x 45°	+/-0.030	0.19 x 45°	✓			
S	0.50 x 45°	+/-0.030	0.50 x 45°	✓			
T	0.38 x 45°	+/-0.030	0.38 x 45°	✓			
U	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
V	Ø0.260	+0.005/-0.000	0.260	✓			
W	Ø0.93	+/-0.030	0.929	✓			
X	0.30	+0.030/-0.010	0.304	✓			
Y	0.37	+0.030/-0.010	0.387	✓			
Z	0.75	+0.030/-0.010	0.763	—			
AA	0.25	+0.030/-0.010	0.264	—			
AB	4.00	+/-0.030	4.006	✓			
AC	6.62	+/-0.030	6.625	✓			
AD	0.95	+0.030/-0.010	0.962	✓			
AE	0.37	+0.030/-0.010	0.384	✓			
AF	3.40	+0.030/-0.010	3.40	✓			
AG	6.63	+/-0.030	6.625	—			

Measured by: <u>EP</u>	Audited by: <u>JL</u>	Prototype Approval:	N/A
Date: <u>05/11/22</u>	Date: <u>05/11/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10015	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	<u>[Signature]</u>

RELEASED
05.06.15

DART AEROSPACE LTD	Work Order:	
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. I	Qty:	Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required																																											
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 REFERENCE ONLY (Bag Bluefiles separately)																																											
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: _____																																											
4	MV	Inspect material for defects or damage prior to machining																																											
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521 Dwg Rev: _____ Folio Rev: _____																																											
6	QC2	Inspect parts as they come off the CNC machine																																											
7	MV	Deburr																																											
8	QC8 & 5	Second inspection																																											
9	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>_____</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>_____</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>_____</td></tr><tr><td>16</td><td>D2529</td><td>Washer</td><td>_____</td></tr><tr><td>8</td><td>D2947</td><td>Clamp</td><td>_____</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>_____</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>_____</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>_____</td></tr><tr><td>1</td><td colspan="2">Paperwork package from Step 2</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	8	D2182B055	Rubber Cushion	_____	16	D2274	Radius Block	_____	2	D2521	Bearpaw	_____	16	D2529	Washer	_____	8	D2947	Clamp	_____	16	AN4-15A	Bolt	_____	16	AN960JD416	Washer	_____	16	MS21042L4	Nut (or -4)	_____	1	Paperwork package from Step 2		_____			
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16	MS21042L4	Nut (or -4)	_____																																										
1	Paperwork package from Step 2		_____																																										
10	QC4	Inspect Kit for 100% Completeness on the W/O																																											
11	PK	Identify and pack for shipping as per PPP K10015																																											
12	AC	Cost / part: _____																																											
13	DC	Close W/O Inspect Level 21																																											

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	
D	05.06.20	Forming removed	KJ/JLM	